

Date: Tuesday, 22/04/2008 3:53:34 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 38760					
Estimate Number	: 12731					
P.O. Number	:			Part Number	: D353535	
This Issue	: 22/04/2008		S.O. No. :	Drawing Number	: D3535 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 38433			Material	:	
Written By	:			Due Date	: 02/05/2008	
Checked & Approved By	: <u>JLD 08-4-23</u>			Qty:	16	Um: Each
Comment	: Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		15.	
		Comment: Qty.: 0.8423 sf(s)/Unit Total : 13.4770 sf(s) 304/316 .040 Sheet (M304S20GA)	
		Batch: <u>107744</u> <u>B 8-4-25</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535	
		Dwg Rev: <u>B</u> <u>B 8-4-25</u>	
		Prog Rev: <u>B</u>	
		2-Deburr if necessary <u>B 8-4-25</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>B 8-4-25</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>B 8-4-25</u>	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 3-Identify as D3535-35.	
		<u>SP 08/04/28</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:34 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38760

Part Number: D353535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



B38760

D353535
29/04/2008

Comment: INSPECT WORK TO CURRENT STEP

08/04/28 X17

7.0 POWDER COATING POWDER COATING



POWDER COATING



M105412

S.139 08.55
#1 3.6.6 F
#2 30 F
#3 30 F
#4 ----- F

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

08-04-29

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/04/29

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

08-04-29

X17

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/30 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38760
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

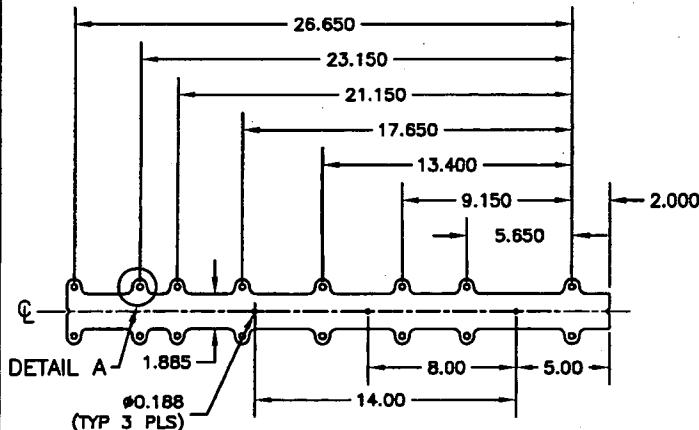
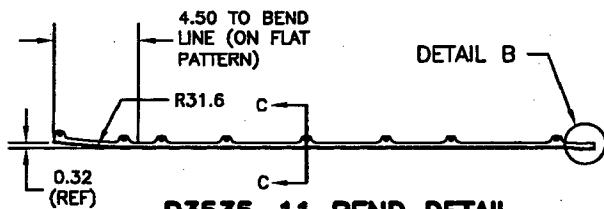
Measured by:	\$	Audited by:		Prototype Approval:	N/A
Date:	8-4-28	Date:	08/04/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>(initials)</i>	<i>E</i>

DART

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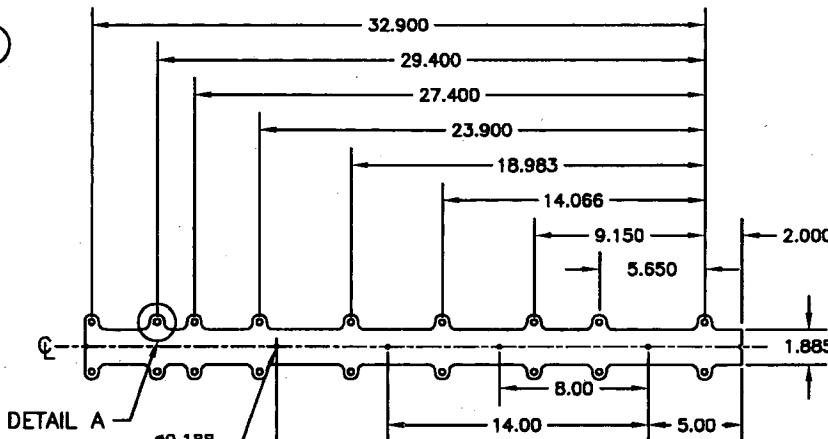
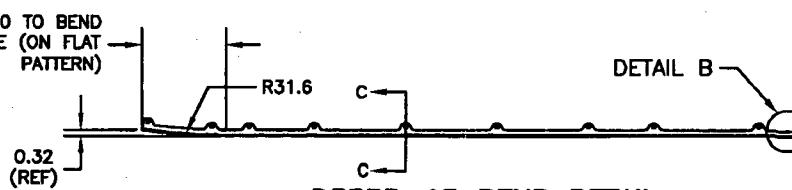
07.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3876

NOTES

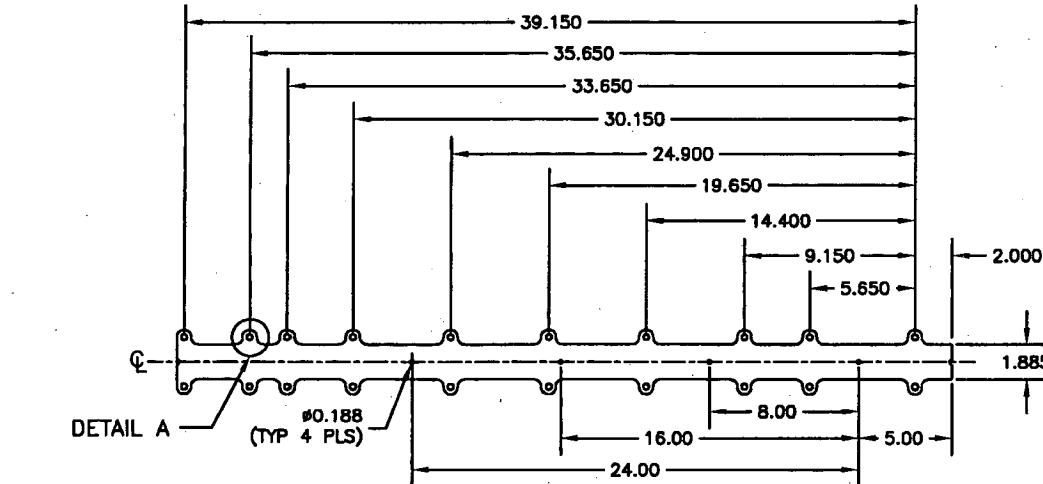
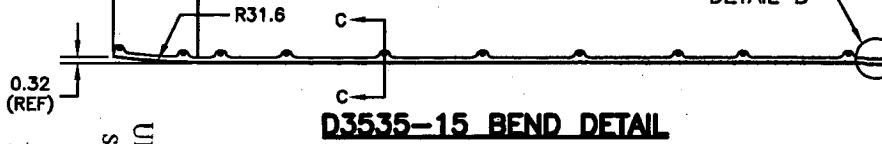
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

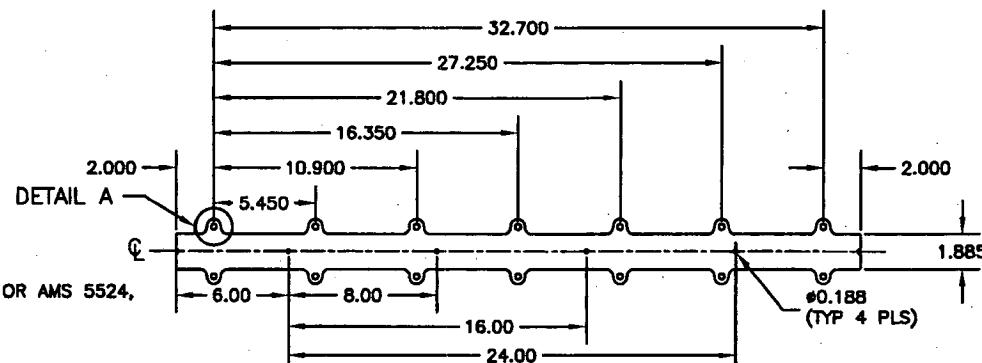
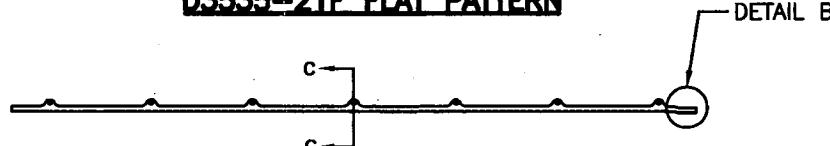
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C8	PH	PORT HADLOCK, WA
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<i>TH</i>	<i>TH</i>	D3535
DATE		SHEET 1 OF 7
07.04.17		SCALE
A	06.10.25	REV. B
B	07.04.17	1:10
		WEARSHOE
		MOVE TAB OUTBOARD, ADD AMS SPEC

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07.04.24

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**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

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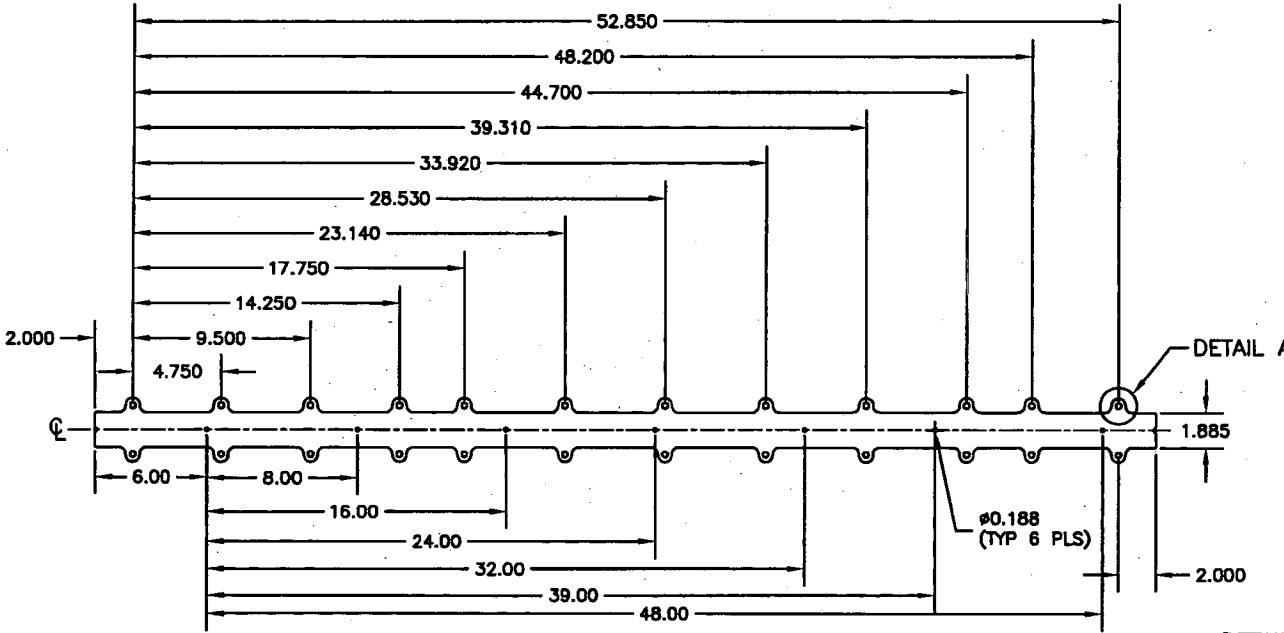
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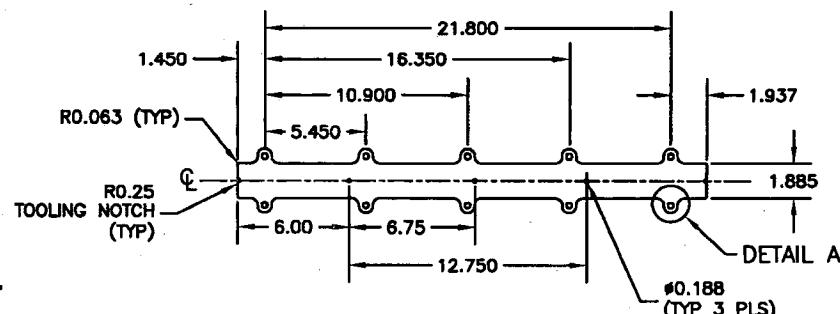
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D3535-23 BEND DETAIL

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NOTES

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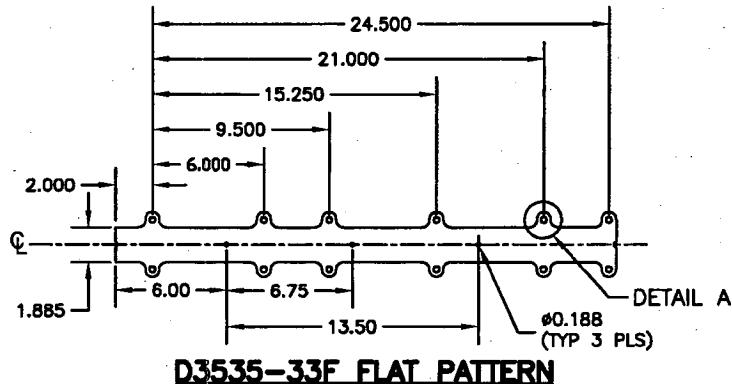
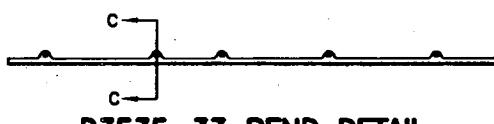


D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

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07.04.17**D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

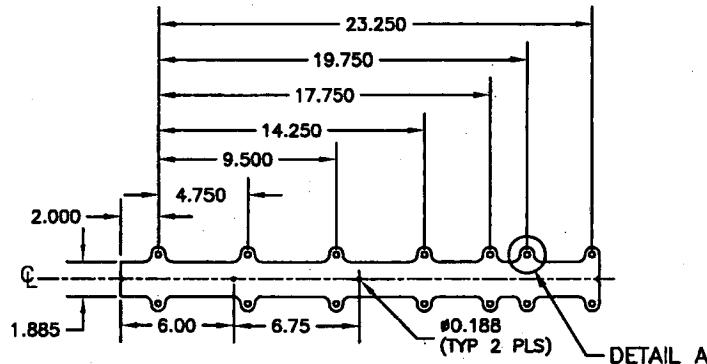
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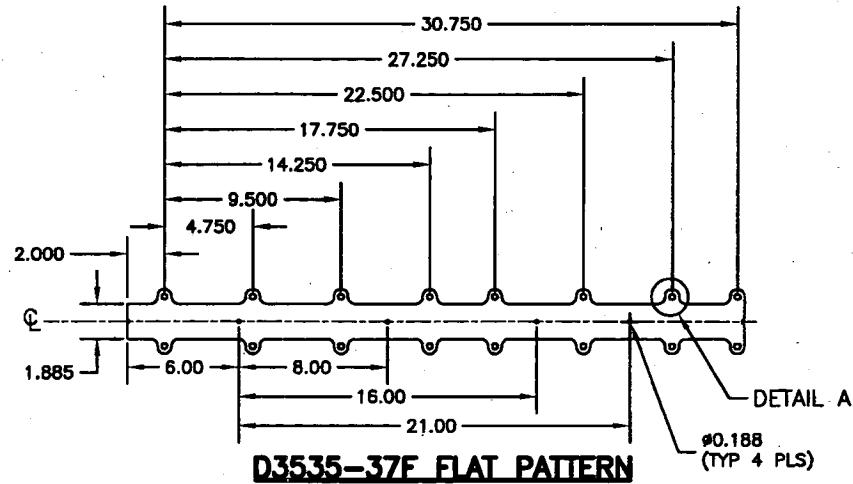
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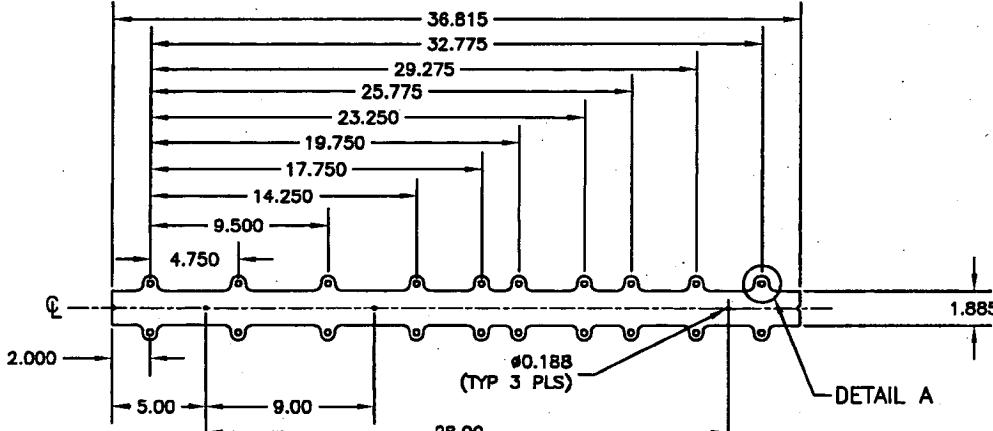
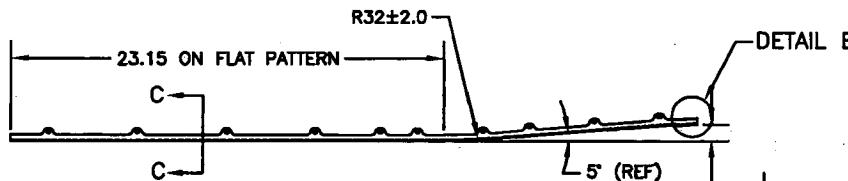
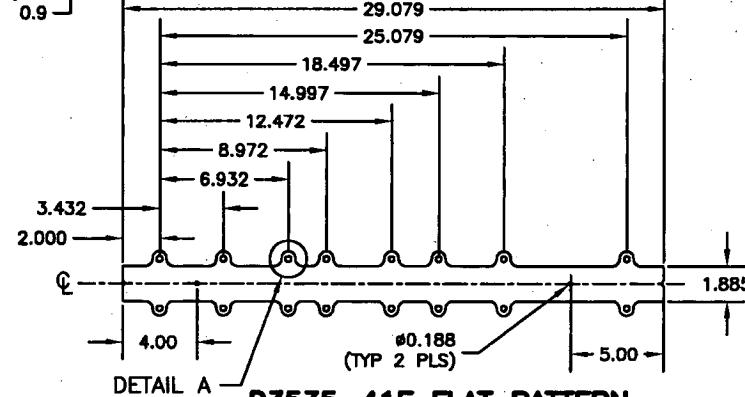
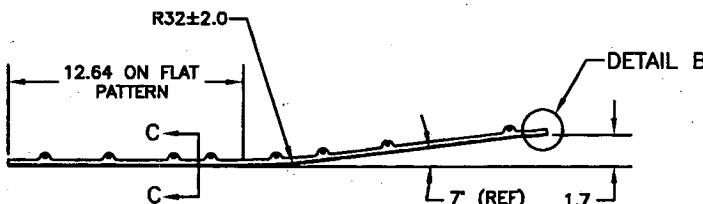
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		TITLE
		WEARSHOE
SHEET 5 OF 7	SCALE	REV. B
	1:10	

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07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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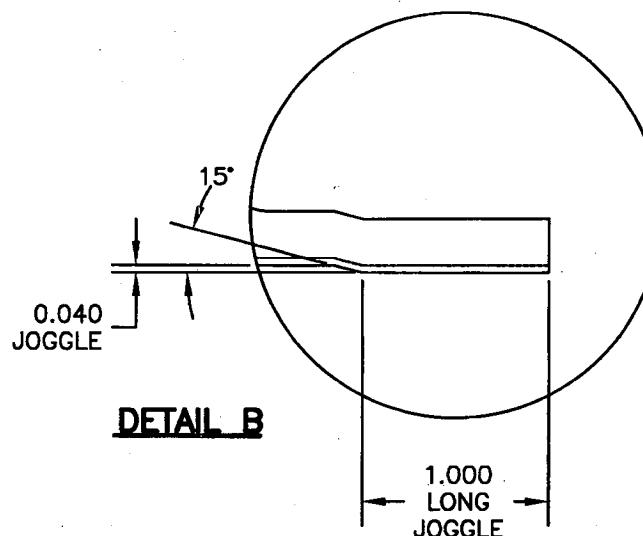
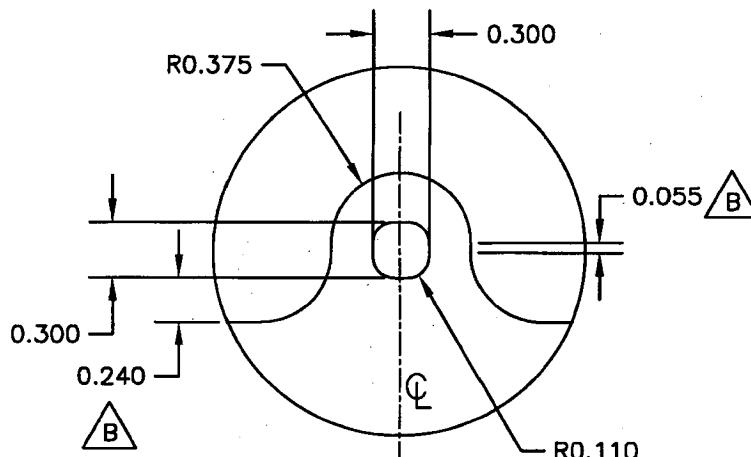
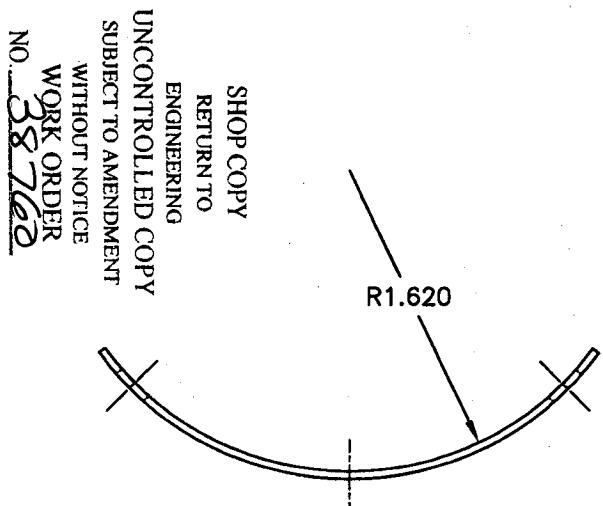
NOTES

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CHECKED /	APPROVED /	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B
		SHEET 6 OF 7
		SCALE 1:10

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DESIGN C-B	DRAWN BY MH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

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07.04.24 *[Signature]***DETAIL B****DETAIL A****SECTION C-C**

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